

Work Order ID 54229

December 3, 2009 2:45:50 PM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID: D/A1

Stop



Item Name: Rear Locker Extender

Start Date: 12/03/09 Start Qty: 1.00



Cust Item ID:

Required Date: 1/08/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL

Date: 09/12/03 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

2

HJ for CL 09/12/21

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 108967
Description: D350-604-041 Rear locker extender.
Supplier: Delastek.
Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B M112919

M 09-12-3 CL
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54229

December 3, 2009 2:45:50 PM

Page 2

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Revision ID: D/A1

Item Name: Rear Locker Extender

Start Date: 12/03/09 Start Qty: 1.00

Required Date: 1/08/10 Req'd Qty: 1.00

Reference:




Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Receive & Inspect for Damage & Mat'l Certs Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.								
130 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Check hole locations to template. DT 8824 Check process sheet and audit.								
140 	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

9/12/18 (1)

9/12/18

X

9/12/18 SP (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 54229

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Page 3

Item ID: D350-604-041

Accept



Setup Start



Revision ID: D/A1

Stop



Item Name: Rear Locker Extender

Start Date: 12/03/09 Start Qty: 1.00



Cust Item ID:

Required Date: 1/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC4- 100% Inspect kits for completeness	0.00				1			12-21
QC Quality Control	Memo	0.00							
160 	Packaging	0.00							12-21
Packaging Packaging	Memo Identify and pack for shipping as per PPP D350-604-041 □ Location: _____ □ PPP Rev: _____	0.00							
170 	QC21- Final Inspection - Work Order Release	0.00							12-22
QC Quality Control	Memo	0.00							

C209/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 3, 2009 2:45:50 PM

Page 1

Work Order ID: 54229

Parent Item: D350-604-041RevD/A1

Parent Item Name: Rear Locker Extender





Comments:

Start Date: 12/03/09

Required Date: 1/08/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
2600-6  Camlock Stud		Purchased	No			100	Each	66.0000	4.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>112919</div> <div>Loc Qty</div> <div>66</div> <div>66</div> <div>Loc Code</div>												
D2269RevB1  Decal		Manufactured	No			120	Each	13.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>52916</div> <div>Loc Qty</div> <div>13</div> <div>13</div> <div>Loc Code</div>												
D350-604-041P  Rear Locker Extender		Purchased	No			140	Each	0.0000	1.0000			
D2268RevB1  Decal		Manufactured	No			150	Each	21.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>47289</div> <div>53484</div> <div>Loc Qty</div> <div>21</div> <div>1</div> <div>20</div> <div>Loc Code</div>												

11/29/19 SP

4
9/12/18 SD

54229 LC 9/12/21

9/12/18 SP @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE NTS
A	02.04.01	NEW ISSUE	
A1	RF 02.04.23	ADD D2728-1 DECAL + ORIENTATION NOTE REAR LOCKER EXTENDER (D2273)	

RELEASED
02.04.03

C209112103
W10.54229

RETAINING WASHER
2600-LW (4)

△
INSTALL D2728-1 DECAL
IN DEPRESSION ON INSIDE
BACK WALL

CAMLOCK STUD
2600-4 (4)

DECAL (D2268)
TOTAL WEIGHT IN THIS COMPARTMENT
NOT TO EXCEED 15 LBS (7 KGS)

UP
△
A1

D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



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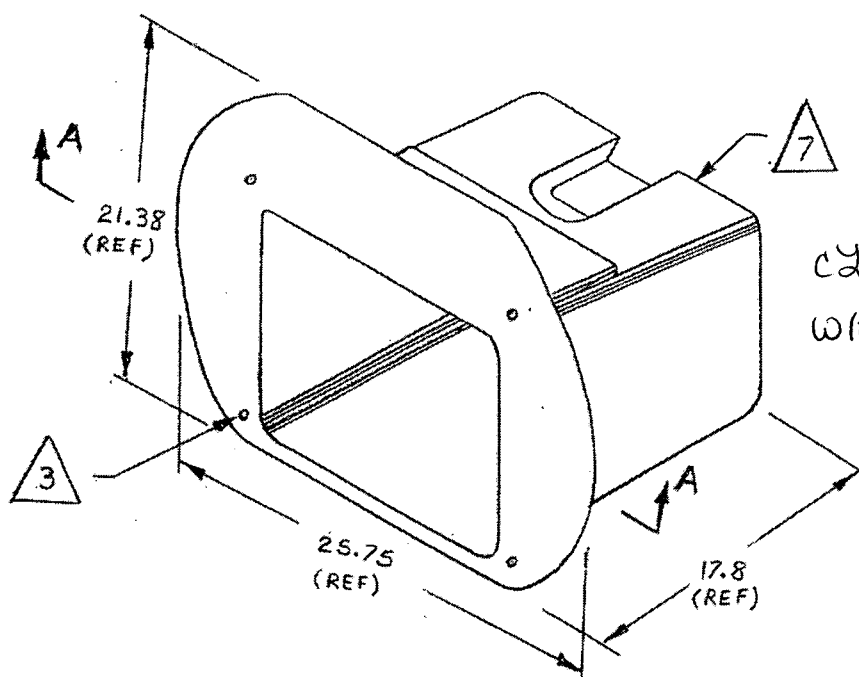
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DART



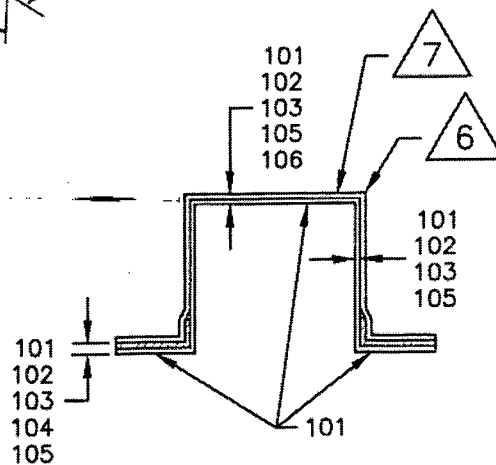
DESIGN	JB	DRAWN BY	JP	DART AEROSPACE LTD	REV. D
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	JH	APPROVED	JS	DRAWING NO.	D2273
					SHEET 1 OF 1
DATE	02.04.01	TITLE	350 REAR LOCKER EXTENDER	SCALE	NTS
B	96.05.27	RE-DRAWN			
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING			
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH			

RELEASED
02.04.03



NOTES:

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP—NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO $\phi 0.257$ (4 PLACES).
- 4) MATERIALS:
RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:
101—WHITE GLOSS GELCOAT # GEL 944W005.
102—9oz ALL OVER.
103—18oz ALL OVER.
104—18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.
105—9oz ALL OVER.
106—PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.



SECTION A-A

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13270
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
17/12/2009	04/12/2009	6074	Chantal Lavoie		PO10887		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0		DKC134-0003	Item 1 Rear Locker Extender D350-604-041P B54229 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D Job: 22708 8 09/12/14			
1	0	1	DKC134-0003	Item 2 Rear Locker Extender D350-604-041P B54230 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D Job: 22736			
1	0	1	DKC134-0003	Item 3 Rear Locker Extender D350-604-041P B54231 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D Job: 22737			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Mercredi, 2009-10-21 13:14:54
 Utilisateur: Louis Jodoin

Feuille de Procédé

Client :	DART US DART AEROSPACE LTD	Nom Dessin :	REAR LOCKER EXTENDER
Numéro Job :	22708	Numéro Article :	DKC134-0003
Numéro Soumission :	3482	Numéro Dessin :	D350-604-041 & D2273
Numéro B.A. :		Projet Numéro :	DK-362
Cette fois :	2009-10-21	Révision dessin :	A & D
Prsht Rev. :	NC	Matériel :	Derakane 470-36/411/510
Prem. fois :	- -	Date Dûe :	2009-10-28
Job précédente :	22707	Qté:	1 UdM: UNITE



Écrit par : _____
 Vérifié & Approuvé par : _____
 Commentaires : N° de pièce Laminée Dart Aerospace: D2273
 N° de pièce Assemblage Dart Aerospace: D350-604-041

Process Sheet Rév.: 00 Création du premier à partir de la révision
 12 du planning De Delastek Composites

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0085	FREKOTE 3,78L 44-NC
-----	--------	---------------------

Commentaire Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Nettoyer le moule à l'aide d'un chiffon humide et sécher à l'air. Selon I.F. # DKC134-0003-5.

Note: Afin que le frekote agisse pleinement, le moule doit être libre de toute contamination, enlever tout contaminants à l'aide de Frekote PMC, PMC Plus ou tout autre solvant efficace. Il est permis d'utiliser un abrasif (Doux) afin d'enlever toute accumulation de résine sur le moule.

Appliquer 2 couches de Frekote 44-NC à l'aide du chiffon propre en laissant sécher pendant 15 minutes entre les couches. Le séchage de la dernière couche doit être de 3 heures à température de la pièce avant d'appliquer le Gel Coat.

Date: _____ Sceau: _____

3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentaire Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)

Gel Coat Blanc N° Gel 944W005

N° de Lot: 1-26097-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentaire Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22196-1

Date: mercredi, 2009-10-21 13:14:55
Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 22708

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

17.0	DÉMOULAGE	Démoulage de la pièce
------	-----------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F.# DKC134-0003-5.

Faire le démoulage de la pièce en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager .

Autocontrôle de fabrication.(Visuel)

Date: 11-12-9 Sceau:



18.0	TRIMAGE	Trimage / Rivetage
------	---------	--------------------



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon I.F.134-0002

Autocontrôle de fabrication.(Visuel et dimensionnel selon le dessin)

Date: 11-11-9 Sceau:



19.0	AAC1021	Dupont Primer N° 7704S
------	---------	------------------------

Commentair Qty.: 0.3400 UNITE(s)/Unit Total : 0.3400 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-25612-2

20.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
------	---------	---

Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-24359-3

21.0	PRIMER	Application primer
------	--------	--------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon I.G. 0008

Date: 11/12/09 Sceau:



22.0	AAC1607	Camlock Stud 2600-4 (or Monadnock 1126000-4)
------	---------	--

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)
Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: 1-7177-1

1-25616-1

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 22708

Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

23.0 AAC0682 Washer 2600-LW (1127700)

Commentaire Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot: 1-6687-1

24.0 ASSEMBLAGE Assemblage mécanique



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Selon I.F. 134-0004

Démasquer la pièce.

Assembler les quatre (4) Camlock Stud N° 2600-4 à l'aide des Lock Washer N° 2600-LW. Selon l'instruction de travail N° I.G.#Pose de stud.

Autocontrôle de l'assemblage (Visuel)

Date: 15 déc 09 Sceau:



25.0 IDENTIFICATION Identification à encre indélébile



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F. 134-0005

Faire l'identification de la pièce: N° de pièce D350-604-04
N° de Work Order: # 22708

L'identification doit être vers l'extérieur.

DEC 15 2009

Date:

Sceau:



26.0 INSPEC FINAL Inspection finale



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 15-12-09 Sceau:



27.0 EMBALLAGE Emballage & Entreposage



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage de la pièce dans le contenant approprié.

Date: Mercredi, 2009-10-21 13:14:55
Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 22708

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 16/12/09

